

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 36045
Estimate Number : 10606
P.O. Number : N/A
This Issue : 11/29/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 11/29/2007 Type : SMALL / MED FAB
Previous Run : 33113

Drawing Name : WEARPLATE
Part Number : D33193
Drawing Number : D3319 REV. B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 12/6/2007

Qty: 20 Um: Each

Written By :
Checked & Approved By :
Comment : Est: A 05.05.12 New Issue KJ/JLM
Est Rev: B Now on Waterjet 06-10-03 JLM

Additional Product

Job Number:



Seq #: Machine Or Operation: Description:

1.0 M1010S18GA 1010/1025/A21/6aA SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total: 68.3004 sf(s)
1010/1025/A21/6aA SHEET .048" Thick
Batch: 106348 IB 07-12-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3319
Dwg Rev: B
Prog Rev: B

IB 07-12-4

2-Deburr if necessary IB 07-12-4

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

504/12/05 (2)

SD

Date: Thursday, 11/29/2007 11:17:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36045

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SP 07/12/05

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

SP 07/12/05 (X2)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

split

Qty Part Number Description
A/R N/A 7560 Hardcoat Rod

Batch

M105844

FC 08 01 08

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Dec 5 08/01/09 (B)

QC9 -> 10 08-01-09 (15)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

m-f 08/01/09

(15x)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

HD

08-01-09

(15x)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: 496

8/1/11 SP

(15x)

DART AEROSPACE LTD		Work Order:	36045
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

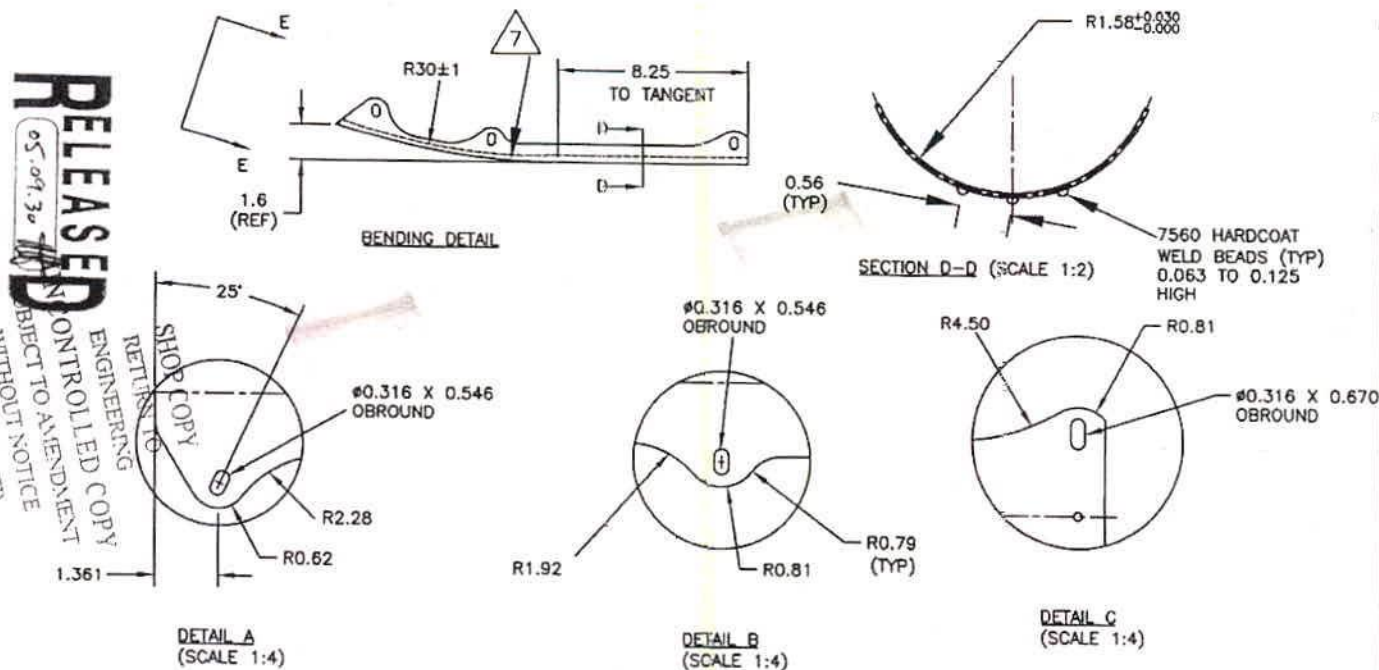
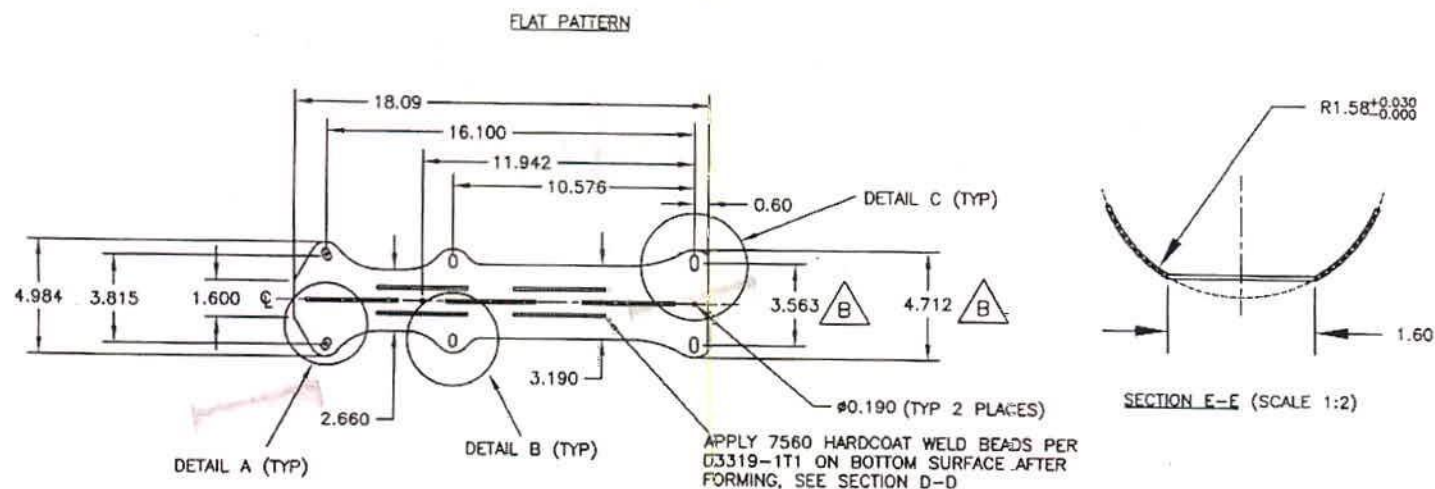
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	x			
74.420	+/-0.010	74.42	x			
62.770	+/-0.010	62.770	x			
52.890	+/-0.010	52.890	x			
30.790	+/-0.010	30.790	x			
8.690	+/-0.010	8.690	x			
0.60	+/-0.030	.60	x			
2.690	+/-0.010	2.700	x			
2.940	+/-0.010	2.950	x			
3.527	+/-0.010	3.520	x			
4.518	+/-0.010	4.516	x			
Ø0.190	+0.005/-0.001	.190	x			
2.940	+/-0.010	2.948	x			
2.940	+/-0.010	2.948	x			
2.690	+/-0.010	2.700	x			
5.063	+/-0.010	5.061	x			
6.163	+/-0.010	6.163	x			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	.315 x .603	x			
0.048	+/-0.010	.048	x			

Measured by:	HB
Date:	07-12-14

Audited by:	J
Date:	07/12/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	AF

DART**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
		SCALE
		1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

RELEASED
05.07.30

CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 36045
WORK ORDER

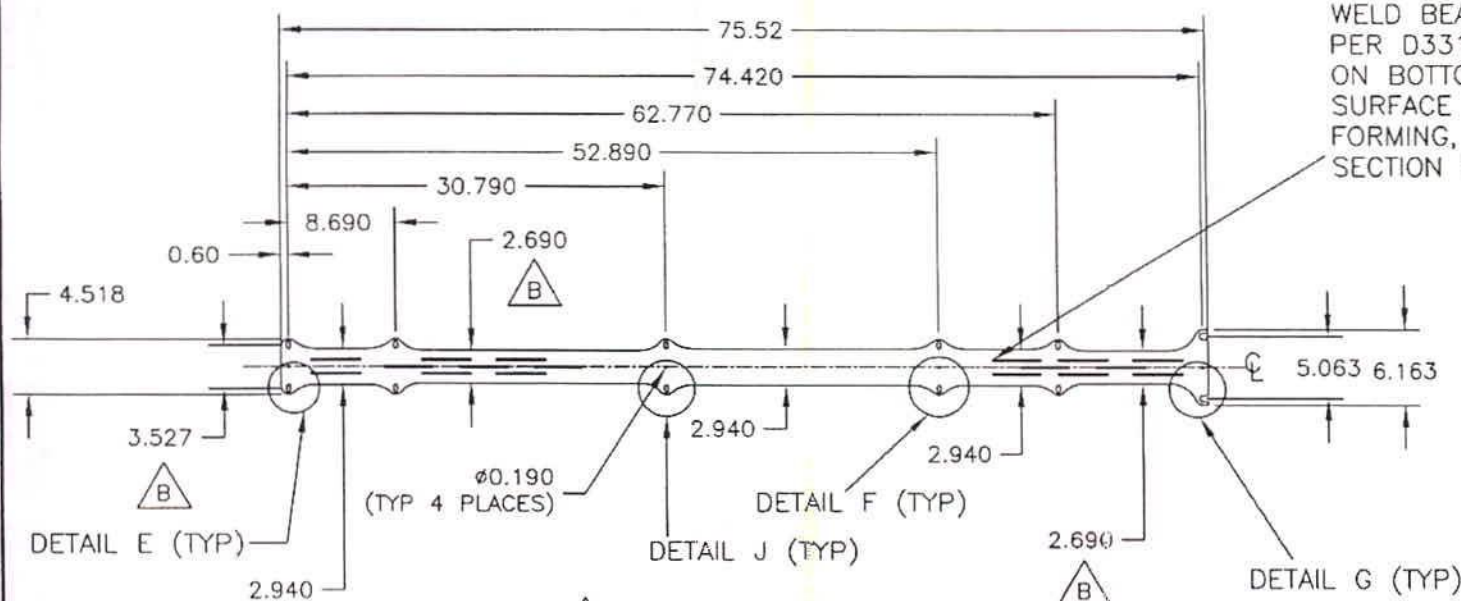
DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED	04	APPROVED	04	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 2 OF 5
				SCALE 1:15

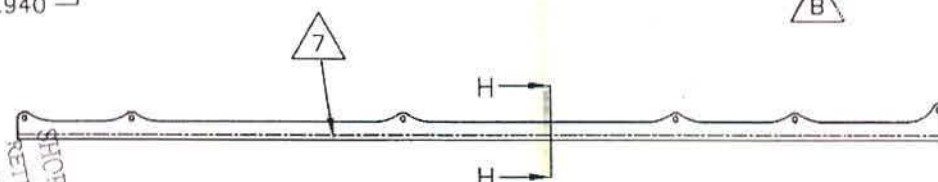
APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

RELEASED
05-07-30

FLAT PATTERN



BENDING DETAIL

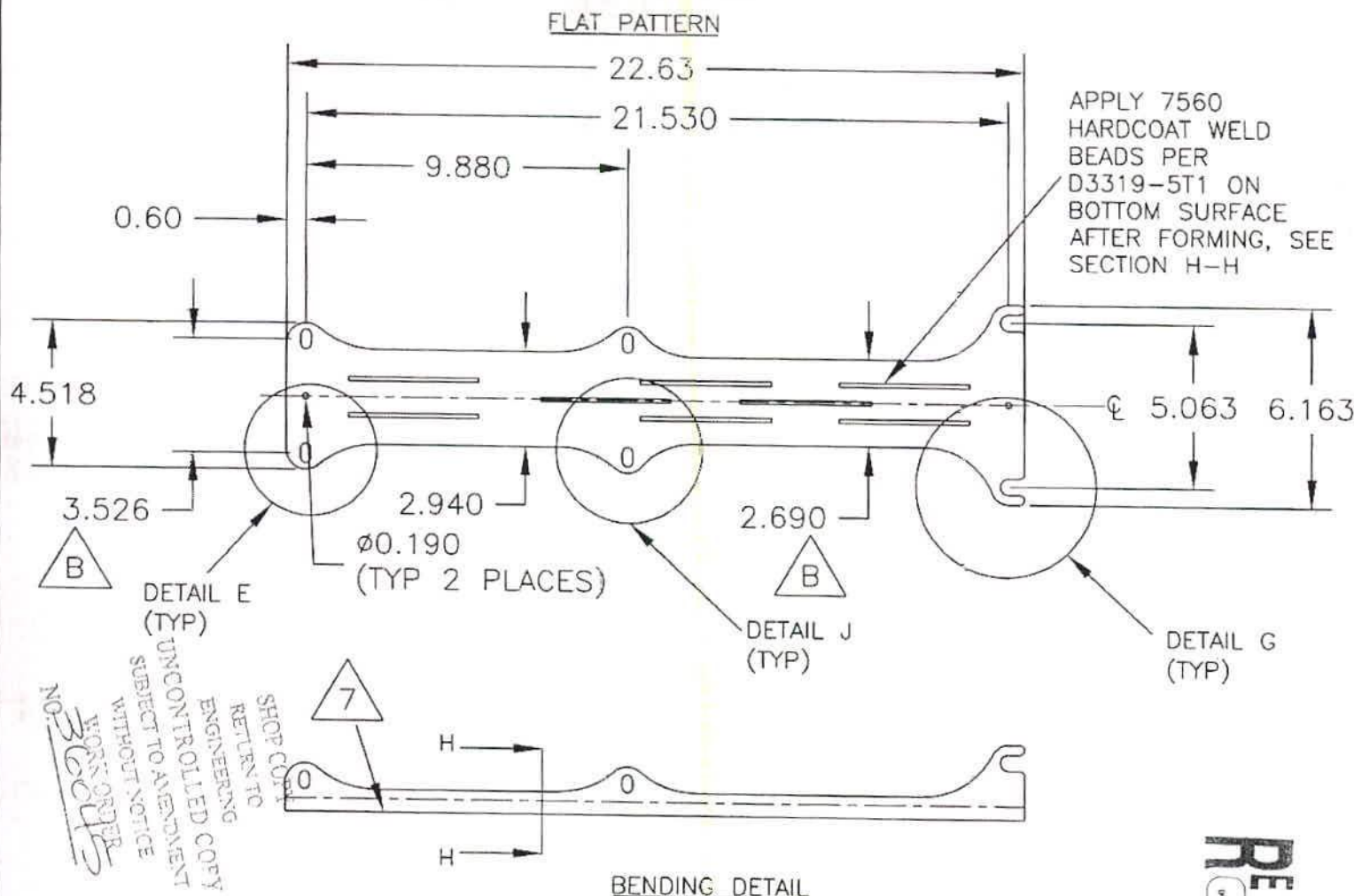


D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 3 OF 5
	TITLE	SCALE
	WEARPLATE	1:5



D3319-5 WEARPLATE

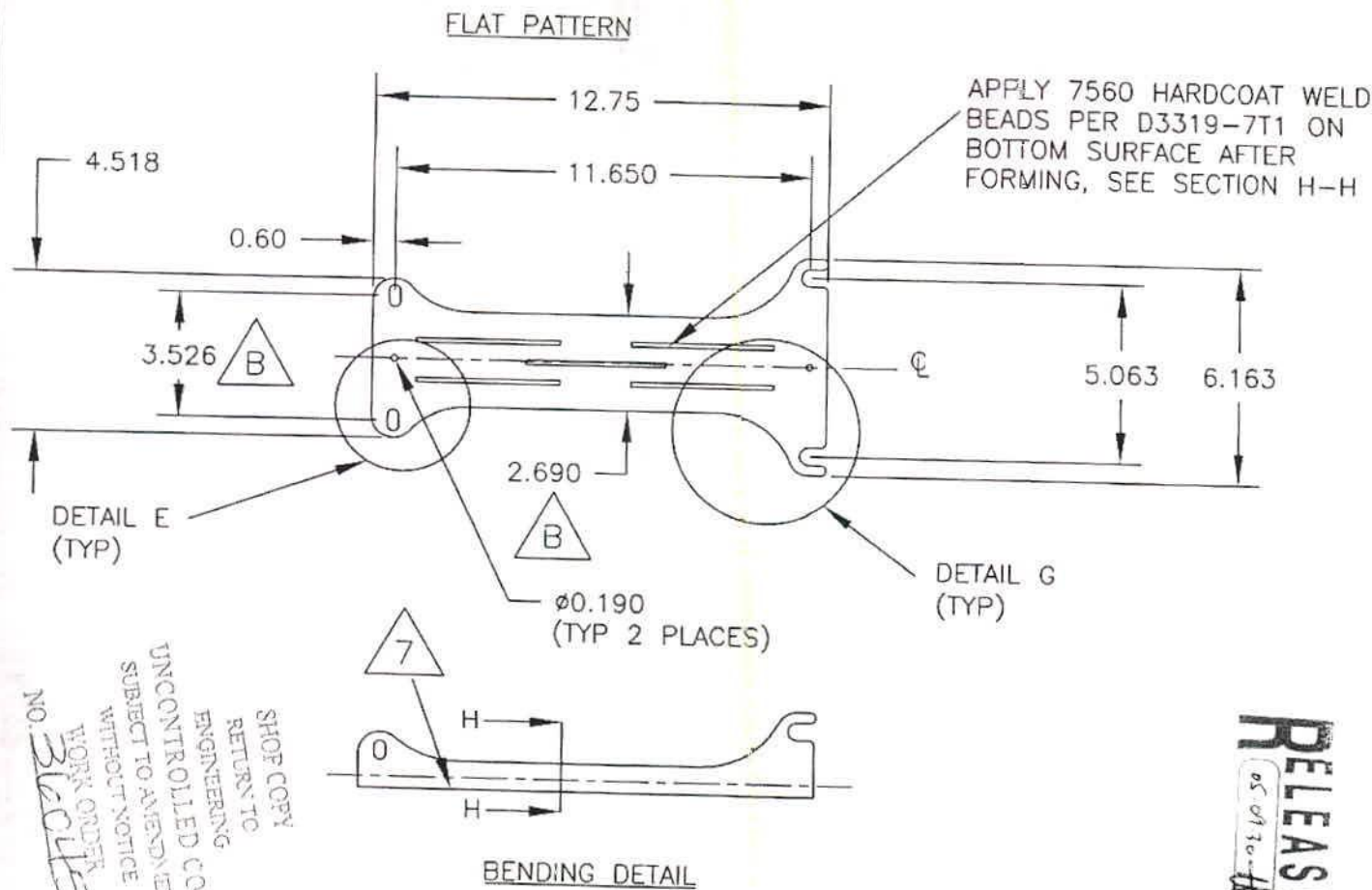
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-07-30-11

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
				SCALE 1:5

RELEASED
05.07.10-11



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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